

Date: Thursday, 21/06/2007 2:57:31 PM  
 User: Linda Lacelle

## Process Sheet

Split 2

07-10-31

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TOW RING
Job Number	: 33099-2		
Estimate Number	: 10396		
P.O. Number	:	Part Number	: D2968041
This Issue	: 21/06/2007	S.O. No. :	Drawing Number : D2968
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: //	Drawing Revision	: B1
Previous Run	: 31957	Material	:
Written By	:	Due Date	: 10/07/2007
Checked & Approved By	<u>L</u>	Qty:	20
Comment	: Est:C 03.04.11 Reformat; Incorporated D2968-1/5 KJ/RF	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 Weld D2968-1 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-041 Batch: 102226	FC 07/06/23 20
2.0	D29681	Stem	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Stem 176302	FC 07/06/23 20
3.0	D29685	Ring	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Ring 17325038	FC 07/06/23 20
4.0	QC9	VISUAL WELDING INSPECTION	
		Comment: VISUAL WELDING INSPECTION	FC 07/06/23 20
5.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	FC 07/06/25 20
6.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH	
		Comment: Sub-Contracting PURCHASING Issue P/O: 4038 Description: D2968-041 to heat treat to ultimate tensile strength 125ksi as per Dwg D2968	FC 07/06/25 20 (20) (20)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 33099

Part Number: D2968041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Conformity sheet required

710! 5683 C208/02112 (S)

Issue P/O: 4039

C207/04125

(20)

Cad Plate per QQ-P-416F Class I Type II

Conformity sheet required

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached



INSPECT WORK TO CURRENT STEP

*EF 02/03/25 (20)*

*08/03/13 (X5)*

*En start 08/03/17*

*08/03/13 (20) parties*

8.0

QC5



Comment: INSPECT CAD PLATE

9.0

POWDER COATING

POWDER COATING



*m107005 BR 08-03-17*



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.2) as per QSI 005 4.3

\*\*\*DO NOT POWDER COAT THREADS\*\*\*

*fx*

*07/07/30*

*(20)*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*M-A*



*08/03/17*

Comment: INSPECT POWDER COAT

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 464

*8/3/11*

*SP*

*(5x)*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



*D 08/03/10*

*(5)*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*W 08/03/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7/10/31	10.0	After Powder coating, the nick plating is easily chipped off on 5 parts. see NCR 246	J QS1042	- Strip to remove Powder cont.	M-L 07/11/08 AS 07-11-08		J QS1042	J 07/10/31

NOTE: Date & initial all entries

# Non-Conformance Report

NCR 246

Raised by:	<u>Jason Murdoch</u>	Source:	<u>Q.C.</u>	Sheet No.	<u>1 of 1</u>
Non-Conforming Dept./Supplier:	<u>Supplier / Manco-Domplex</u>			Date:	<u>07-10-31</u>
Product/Service:	<u>D2968 - 041 Tow Rings</u>			Priority:	<u>HIGH</u> <u>LOW</u>

Area of Standard:	<b>Section A</b> <b>Description of Non-Conformance</b> Crcl plating is easily peeled off of the tow rings, After Powder coating. Parts appear (looks like) to be all cracked, due to the crcl plating lifting. Only 5 parts affected from this batch of 20.				
QSI					
QSP					
QSPM					
Documents:					
P/O 4039					
Invoice					
W/O					
Batch No. 33099					
TSR					
Drawing D2968 Rev: B1					

Forward to Director, Quality Assurance on completion of this box

DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.

Section B Corrective Action		Responsible for Investigation/CA: <u>L.Lacelle</u>	To be done by: <u>07-11-30</u>		
No	Initial	Action Description	Responsible	Due date	Sign/Date
1		<u>Return parts to Manco to be correctly re-crcl-plated.</u>	<u>C.Lawrie</u>	<u>07-10-10</u>	
			Fault Category:		
Preventive Action Required: NO YES # _____					

Section C Verification of C/A		Responsible for Verification of CA:		
No	Verification Method	Sign	Date	Forward to DQA on Completion of Verification  DQA: _____ Date: _____
QA Purposes only		N/C Closed		Date



**Placage  
Manco Domplex  
Electroplating**

Siège social / Head Office Plan 1  
4660 Hickmore 4670 Hickmore  
Ville St-Laurent, Québec Ville St-Laurent, Québec  
H4T 1K2 Fax: 514-355-5991  
Fax: 514-355-8750

Plan 2  
8001 Larrey  
Anjou, Québec  
Fax: 514-354-2937

**BON DE LIVRAISON  
PACKING SLIP**

Tél.: 514-355-7867 / 1-877-355-7867

V S \_\_\_\_\_  
E O \_\_\_\_\_  
N D \_\_\_\_\_  
D U \_\_\_\_\_  
T A \_\_\_\_\_  
O \_\_\_\_\_

Dart Aerospace LTD

EXPÉDIE TO Dart Agassiz (nv)  
SHIP TO 1270 Abell floors 7  
MEMO Hawksbury ONT K6A 1

**AUCUNE RÉCLAMATION APRÈS 5 JOURS DE LA DATE DE LIVRAISON  
NO CLAIMS AFTER 5 DAYS FROM DATE OF DELIVERY**

COPIE BLANCHE / WHITE COPY: BUREAU / OFFICE - COPIE Verte / GREEN COPY: CONFIRMATION D'EXPÉDITION / SHIPPING CONFIRMATION  
COPIE ORANGE / ORANGE COPY: CLIENT / CUSTOMER - COPIE BLEU / BLUE COPY: FICHE D'EXPÉDITION / SHIPPING FILE

# BON DE LIVRAISON  
**109405**

**MANCO  
DOMPLEX**

8895 Crescent 3  
Anjou (Québec) H1J 1R6  
Tél.: (514) 355-7867  
Fax: (514) 355-8750

ATTN: CHANTAL - 1613-632 105's

CERTIFICAT DE CONFORMITÉ  
CERTIFICATE OF COMPLIANCE

# 424

Dalt Aerospace Ltd

Client / Customer

P05683

Votre # de commande / Your purchase order #

1 lot of pieces

# de la pièce / part #

109405

Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector	Date, équipe / Date, shift	
Leverault	Feb 28, 2008	
Placage / Plating	QQP416E CUI Type II	
Quantité totale / Total quantity	1 lot	Quantité inspectée / Inspected quantity
Adhérence / Adhesion	Good	
Épaisseur / Thickness	L.C.D	H.C.D
		Moy. / aver.
		0.0005
Coulisses, taches / Leach, spots	Nor	Rugosité / Roughness
Quantité approuvée / Approved quantity	1 lot	Quantité rejetée / Rejected quantity
Commentaires / Comments		

D2968-041 B33099 = 595

D3028-1 B33369 = 259-5

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Sigé au nom de  
Signed on behalf of

**MANCO  
DOMPLEX**